



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D3639-2**

**Job Sheet 176787**



**Part No:** D3639-2

**Job Qty:** 20 ea

**Part Name:** Doubler



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 5/1/18

**Job Tracking No:**

**Due Date:** 5/18/18

**Created By:** Michelle Gagnon-Donovan

**Type:** Stock

**Description:**

**Note:** DWG REV A IPP Rev:A New Issue 07-07-20 JLM Verified By:EC IPP Rev:B remove c'sink DD 10.04.13 verified by:EC

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|       |                    |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 90    | Start up Operation | 20 Ea  | 5/18/18    | 5/18/18  | 0.00      | 0.00    | Start Up Waterjet     |           | SC 8/05/09     |
| 100   | Waterjet           | 20 pcs | 5/18/18    | 5/18/18  | 0.00      | 1.53    | Waterjet1             |           | SC 8/05/09     |
| 110   | QC                 | 20 pcs | 5/18/18    | 5/18/18  | 0.00      | 0.00    | QC2 Waterjet-2        |           | SC 18/05/09    |
| 120   | QC                 | 20 pcs | 5/18/18    | 5/18/18  | 0.00      | 0.00    | QC8-3                 |           | 38             |
| 140   | Brake NC           | 20 pcs | 5/18/18    | 5/18/18  | 0.09      | 0.44    | Brake NC 1            |           | DAB 38         |
| 150   | QC                 | 20 pcs | 5/18/18    | 5/18/18  | 0.00      | 0.00    | QC5                   |           | 38             |
| 160   | HandFinish         | 20 pcs | 5/18/18    | 5/18/18  | 0.00      | 1.31    | HandFinish1           |           | SAP 05-24      |
| 170   | QC                 | 20 pcs | 5/18/18    | 5/18/18  | 0.00      | 0.00    | QC7-2                 |           | 11 MAY 25 2018 |
| 175   | QC                 | 20 pcs | 5/18/18    | 5/18/18  | 0.00      | 0.00    | QC5                   | N/A       | 9-89           |
| 180   | Packaging          | 20 pcs | 5/18/18    | 5/18/18  | 0.00      | 0.00    | Packaging3-1          | stock     | MAY 28 2018    |
| 190   | QC21-SA            | 20 Ea  | 5/18/18    | 5/18/18  | 0.00      | 0.00    | QC21                  |           | 21 MAY 29 2018 |

### Job BOM

| Part / Item  | Component Name     | Quantity            | Operation             | Container |
|--------------|--------------------|---------------------|-----------------------|-----------|
| M2024T3S.050 | 2024-T3 .050 Sheet | 4.7800 sf (.239 ea) | 90-Start up Operation |           |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M2024T3S.050   | 5        | 92        | 0         |

### Part Specifications

Specifications could not be found.

Plex 5/1/18 8:37 AM Dart.Gagnon.Michelle



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**Container No: S069966**



**Part: D3639-2**

**Job No: 176787**

**Serial No/Batch: S069966**

**Revision:**

**Inspector:**

**Date: 05/09/18**

|                                     |  |                     |         |
|-------------------------------------|--|---------------------|---------|
| <b>DART AEROSPACE LTD</b>           |  | <b>Work Order:</b>  | 176 787 |
| <b>Description: Doubler</b>         |  | <b>Part Number:</b> | D3639-2 |
| <b>Inspection Dwg: D3639 Rev: A</b> |  | <b>Page 1 of 1</b>  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.625            | +0.008/-0.001 | Ø0,625           | 1      |        | VSC-01               |          |
| Ø0.191            | +0.005/-0.001 | Ø0,192           | 1      |        |                      |          |
| Ø0.098            | +0.004/-0.001 | Ø0,098           | 1      |        |                      |          |
| 0.69              | +/-0.030      | 0,70             | 1      |        |                      |          |
| 1.59              | +/-0.030      | 1,60             | 1      |        |                      |          |
| 2.49              | +/-0.030      | 2,50             | 1      |        |                      |          |
| 3.39              | +/-0.030      | 3,40             | 1      |        |                      |          |
| 3.990             | +/-0.010      | 3,994            | 1      |        |                      |          |
| 4.990             | +/-0.010      | 4,993            | 1      |        |                      |          |
| 5.19              | +/-0.030      | 5,20             | 1      |        |                      |          |
| 6.99              | +/-0.030      | 6,995            | 1      |        |                      |          |
| 8.64              | +/-0.030      | 8,65             | 1      |        |                      |          |
| 0.45              | +/-0.030      | 0,45             | 1      |        |                      |          |
| 0.710             | +/-0.010      | 0,713            | 1      |        |                      |          |
| 2.000             | +/-0.010      | 2,001            | 1      |        |                      |          |
| 2.75              | +/-0.030      | 2,752            | 1      |        |                      |          |
| 3.55              | +/-0.030      | 3,554            | 1      |        |                      |          |
| 4.00              | +/-0.030      | 4,004            | 1      |        |                      |          |
| 2.000             | +/-0.010      | 2,002            | 1      |        |                      |          |
| 2.590             | +/-0.010      | 2,593            | 1      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                     |          |                    |                   |                            |     |
|---------------------|----------|--------------------|-------------------|----------------------------|-----|
| <b>Measured by:</b> | SL       | <b>Audited by:</b> | DAS<br>38<br>2.88 | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b>        | KG/05/09 | <b>Date:</b>       | MAY 14 2018       | <b>Date:</b>               | N/A |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 07.10.19 | New Issue | KJ/EC/DD   |          |